PTO -

NCR:	Yes)/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA JULZ	Date:/3/6/17 *	3
) [[Date: 13/10/16	_

									QA Closed	Date:	12/10/16
Work Order	: 107S	767			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	,
Part No	o. <u>13-</u>	04-		,	Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	- 13/14/16 	no	l	BUT IT STOP	HE Priet IN 16. DID NOT - UP AGAINST Crater Error / Princhat M bela Rung	A.P. 13,10.11	Part accept	ble as	A.P. 13.10.11	13/10/11	DAS 16 9-89 13/10/4
Опарриотеа		1		L	F/	AULT CATE	GORY			1	
Landin	g Gear				General				<u>.</u> ,		
	Bending Centre No Cracks Crushed/		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs		are ion Incomplete tions Incomplete/U	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M	tolerance	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea			<u> </u>	Countersink	Mislabe		_	Positioned V		1
-	Inspectio		Tube	ļ	Cut Too Short	Misrea	d	L	Power Loss/	'Surge	Other
-	Ripples in		Eutrocia	<u> </u>	Drill Holes	Offset	Calibration				<u> </u>
	Turning S			" 	Drawing Finish		Calibration Sequence				
1 F	Turning S Wave/Tw			<u> </u>	Folio	├ ─	sequence E Dimensions				
1	I AND ACTION	rist in Tul	Ų.		טווט ון	i louisiut	DITTICITISTO IS				

Work Order ID September-27-13 12:48		*10	7567*	Page 2	
Item ID: D3204 Revision ID: Item Name: Pedal Start Date: 9/27/13 Required Date: 9/27/13	Start Qty: 6.00	*6* *6*	*N9000401 Cust Item ID: Customer:	00* Setup Start *NS1* Stop *NS2*	
• •		Tooling: SPC (Y/N):	Date:	Run Start *NR1* Stop *NR2*	
Sequence ID/ Work Center ID 130 *130* QC Quality Control	Operation Description QC8- Inspect parts - second check Memo	Set Up/ Run Hours 0.00	Tool ID Tool # P C DAS: 40 9-89 13/10/11	Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp	
140 *140* Packaging Packaging	Identify as per dwg & Stock Locati Memo *****STOCK IN LAR	0.00		10x 28 13-10-11 9-89	
150 *150* QC Quality Control	QC21- Final Inspection - Work Ord Memo	ler Release 0.00		ML5 17-10-11	

NCR:	Yes	/	No

NCR: Y	'es	/ No				WORK ORDER NON-	CONF	ORN	ANCE / UPI	DATE			*****
		·									QA Closed:	Da	te:
Work Orde	er: -					DISPOSITION				F4	EPARTMENT,		
Part N	lo					Rework Scrap	$\frac{1}{4}$	ī	Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Quality
NCR N	lo					Use-as-is Work Order Update	<u> </u>		oforming Large Fab	Finishing Composite	_ Rec/stoi	e/Packaging Supplier	
Root					Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	n QC Inspector
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Landir					_	General				_	7	,	
		Bending	4		<u> </u>	Bend	\blacksquare	rain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (D/S	BOM/Route	Ha	ardwa	re		Over/Under		Temperature/Cure
ļ		Cracks				Broken/Damaged	lns	specti	on Incomplete		Part Incorre		Weld
		Crushed/0	Crimped			Burrs	Ins	structi	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	Шм	ainte	nance		Part Moved		
		Heat Trea	ıt			Countersink	Mi	islabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short	Шмі	isread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	Of	ffset					
		Torque W	aves in E	xtrusio	n [Drawing	ou	ut of C	Calibration				
		Turning S	equence			Finish	Or	ut of S	equence				
		Wave/Tw	ist in Tub	oe .		Folio	Ποι	utside	Dimensions				-

DQA:

Date:

· September-27-13 12:48:19 PM

Work Order ID:

107567

Parent Item:

D3204-9

Parent Item Name:

Pedal

Start Date: 9/27/13

Required Date: 9/27/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: C05.08.11Added Step 25 'KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X02.000 6061-T6 Bar .375 x 2.00		Purchased	No			100	f	16.3240	0.2688	1.6976844			
				<u>Location</u>		Loc Qty	<u>Lo</u>	c Code					
				MAT002		1.8							
				19059	9	1.8							
				MAT049		14.524							
				1144	88	2.524						1 1	,
				M126	6075	12			_2_	83	SW	< 13/1	0/0-3

				DQA:	Date
					_
NICD.	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		
NCN.	162 /	INU	WORK ORDER HON-CONFORMACE / OFDATE		

									·		QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST	DEPARTMENT,	/PROCESS	
Part N	-					Rework Scrap Use-as-is		ſ	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No.				· · · · · · · · · · · · · · · · · · ·	Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	ln	itial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data										• • •			
Equip/Tooling													
Operator	Ш												
Material													
Setup '	Ш			7			1						
Other													
Process	Ш												
Supplier													
Training										•			
Unapproved													
						F/	AULT	CATE	GORY	-			
Landi	ng G	Gear				General						_	_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		łardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Ш"	nspecti	on Incomplete	ļ	Part Incorre	ct	Weld
		Crushed/0	Crimped			Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			ļ	Contamination	∐ ^	√ainte	nance		Part Moved		
	Ш	Heat Trea	t			Countersink	∐^	∕Iislabe	eled		Positioned V	Vrong	
	Ш	Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
		Ripples in	Bend		L	Drill Holes	\square	Offset					
	\sqcup	Torque W	aves in E	xtrusio	n 📙	Drawing		of (Calibration				
		Turning S	equence			Finish		Out of S	Sequence				
		Wave/Tw	ist in Tuk	ре		Folio		Dutside	Dimensions				

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DART AEROSPACE LTD	Work Order:	107567
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		Prot	Prototype			
Drawing	Tolorones		Actual			Method
Dimonolon	Tolerance	_ ا	N	Accept	Reject	Inches

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.501			Dear	6"vern
0.250	+/-0.010	245			1	1
0.080	+/-0.010	.081				
0.110 x 45°	+/-0.010	,110				
0.620	+/-0.010	6145	/		Hi-16 H	Carrier .
3.000	+/-0.010	3.001			1.205	Gruss. 6"vixens.
2.00	+/-0.030	1.995			1,)~08	(,
0.310	+0.010/-0.000	311	~			= Block.
0.780	+/-0.010	780			DROT	6"LERD
1.750	+/-0.010	1.746	-		1	1
Ø0.134	+0.005/-0.000	0.134				1
					<u>.</u>	
						·
2			200			

Measured by:	Audited by:	9-89	Prototype Approval:	N/A
Date: /3/10/10	Date:	13/10/11	Date:	N/A

Rev	Date	Change	,	Revised by	Approved
L_A	05.02.17	New Issue		KJ/JLM	1
В	06.03.21	Dwg Rev update		KJ/JLM X	ad
		**************************************		110,02110	1. ////

NCR: Ye	es / No				WORK ORDER NON-O	CON	IFORI	MANCE / UPI	DATE				
				·						QA Closed:	Date	::	
Work Order	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
					Rework	l f	Skid-tube Crosstube				Water Jet	Engineering	
Part No	0.				Scrap	1	I	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR No	0				Work Order Update]		Large Fab	Composite		Supplier		
Root	t Desc			Descri	tion of work order update	In	nitial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator	_												
Material	_					1							
Setup	_												
Other	_												
Process													
Supplier						1						,	
Training											•		
Unapproved				<u> </u>									
						AULT	CATE	GORY					
Landin					General		<u>.</u>		Γ	1	_	¬₋ ".	
-	Bending				Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced	
-	Centre No	ot Concei	ntric to (^{5/5} -	BOM/Route	-	Hardwa			Over/Under		Temperature/Cure Weld	
-	Cracks	C:		-	Broken/Damaged	-	•	on Incomplete		Part Incorred	<u> </u>	Wrong Stock Pulled	
}	Crushed/ Cuffs	Crimpea			Burrs	\vdash		ions Incomplete/Unance	Inclear	Part Lost/Mi Part Moved	ssing _	wrong Stock Pulled	
-	Heat Trea	.+		-	Contamination Countersink	\vdash	iviainte Mislabe		·	Part Moved Positioned V	Vrong		
- -	Inspection		Tubo	<u> </u>	Cut Too Short	\vdash	Misread		 	Positioned v		Other	
	Ripples in		iube		Drill Holes	\vdash	offset	A	L	Jeowei ross/	Juige [Totilei	
-	Torque W		vtrusio	, <u> </u>	Drawing	\mathbf{H}		Calibration					
	Turning S			' 	Finish	-		Seguence				· · · · · · · · · · · · · · · · · · ·	

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

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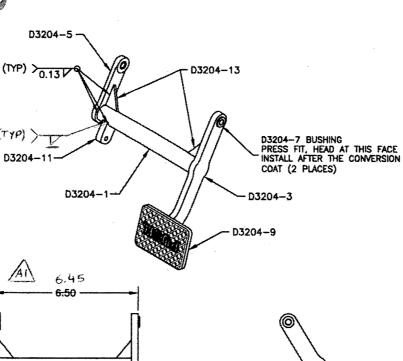




	DESIG	i	DRAWN BY	DART AEROSPACE LTD	
)	CHECK	ED.	APPROVED	DRAWING NO.	REV. A
	DATE			TITLE	SCALE
	04.0	1.27		RELEASE PEDAL ASSEMBLY	NTS
	Α	. *	04.01.27	NEW ISSUE	

>0.13V

05.07.15 6.45 WAS 6.50



D3204-041 RELEASE PEDAL ASSEMBLY

0.600

- BREAK ALL SHARP EDGES 0.005 TO 0.015
- MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B) 4) MATERIAL: AISI 303 SS (M303R)

- MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 WELD ASSEMBLY PER QSI 004
 CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 11) ALL DIMENSIONS ARE INCHES

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												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON- 0	100	NFOR	MANCE / UP	DATE					
												QA Closed:	Da	ate:	
Work Order:						DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other			
Root				l .	Descri	ption of work order update	П	I Initial	Ac	tion	_	Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng	1	ription		Date	Verificatio	n ·	QC Inspector
Doc/Data															3
Equip/Tooling														ļ	
Operator	Ш														
Material	Ш		1	;										i	
Setup	Ш												:	i	·
Other															
Process	Н														
Supplier	\vdash			ļ										!	
Training															
Unapproved			<u> </u>	<u> </u>	<u> </u>		<u> </u>	LT CATE	CORV		_	L			<u> </u>
Landi	na C	Gear	 		··· · · · · · · · · · · · · · · · · ·	General	HUL	LICAIL	GONT		—				
Lanui	Landing Gear Gener						Г	Grain		ſ	_	Ovalized			Pressure/Forced
					BOM/Route	\vdash	Hardwa	are		_	Over/Under	tolerance		Temperature/Cure	
	Centre Not Concentric to O/S Cracks					Broken/Damaged		4	ion Incomplete	Ì		Part Incorred			Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

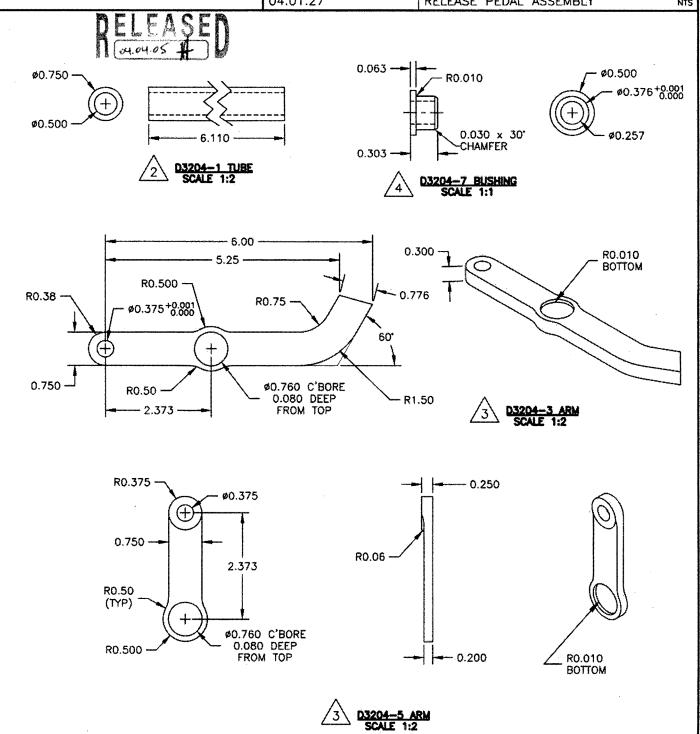
Folio

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DESIGN R	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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NCR:	Yes	/	No

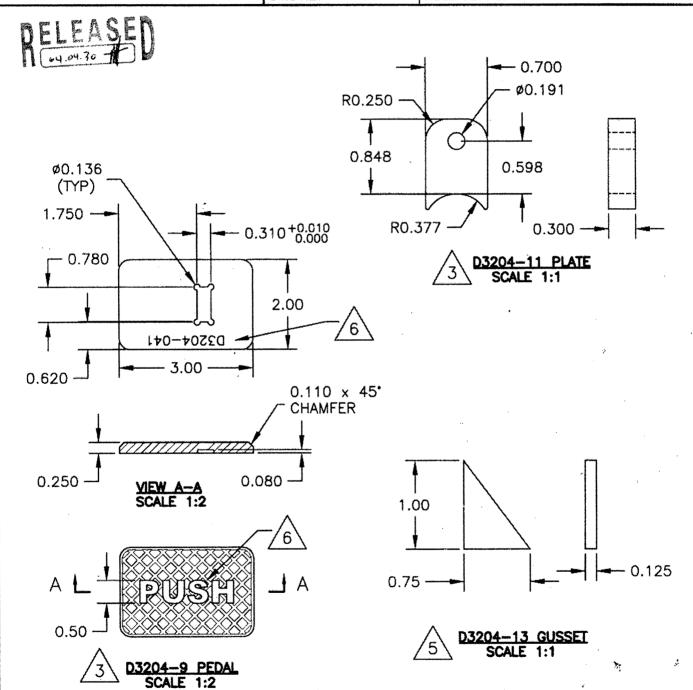
NCR: Y	⁄es	/ No				WORK ORDER NON-CONFORMANCE / UPDATE						_ Date: Date:	
Work Order:						DISPOSITION AGAINS				DEPARTMENT/PROCESS			
Part No. NCR No.						Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite			Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			Quality	
Root		·			Descri	ption of work order update	Initia	ıl	Action	Sign &		-	
Cause		Date	Step	Qty	(or Non-conformance	Chief E	ng	Description	Date	Verifi	cation	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup	Ш												
Other													
Process													
Supplier													
Training													
Unapproved													
						F	AULT CA	ATE	GORY				
Landi	ng G	ear			_	General				-			,
Bending				Bend	Gra	in		Ovalized			Pressure/Forced		

	TAGET CATEGORY											
Land	ing Gear	General										
	Bending	Bend	Grain	Ovalized Pressure/Forced								
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperature/Cure								
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld								
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock Pulled								
	Cuffs	Contamination	Maintenance	Part Moved								
	Heat Treat	Countersink	Mislabeled	Positioned Wrong								
A -	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other								
	Ripples in Bend	Drill Holes	Offset									
	Torque Waves in Extrusion	Drawing	Out of Calibration									
	Turning Sequence	Finish	Out of Sequence									
	Wave/Twist in Tube	Folio	Outside Dimensions									

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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. A
4	-H-	D3204	SHEET 3 OF 3
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04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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DQA:	Date:	
1.4.	3	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCN.	25 / NO				WORK ORDER HOR-	CONTO	MINIAIUCE / O		QA Closed:	Date:			
Work Order	:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap	Scrap Machining Small Fa			4	Water Jet od. Eng. Coor.	Engineering Quality		
NCR No.				·	Use-as-is Work Order Update	Use-as-is Thermoforming Finishir Order Update Large Fab Composit							
Root				Descri	iption of work order update	Initia	Ι Δ	Action	Sign &				
Cause	Date	Step	Qty	,	or Non-confòrmance	Chief E	ng Des	scription	Date	Verification	QC Inspector		
Ooc/Data quip/Tooling						×				***			
Operator Material	<u> </u>												
Dther											·		
Process				in .					·	•			
Training Inapproved					· · · · · · · · · · · · · · · · · · ·								
						AULT CA	TEGORY						
Landing					General □_				1		1		
-	Bending	_			Bend	Grai			Ovalized	·	Pressure/Forced		
-	Centre No	ot Conce	ntric to	0/5	BOM/Route		lware		Over/Under Part Incorre	-	Temperature/Cure Weld		
-	Cracks Crushed/	'Crimmod		.	Broken/Damaged Burrs	⊢ '	ection incomplete uctions incomplete	-/Uncloar	Part Incorre) ——	Wrong Stock Pulled		
	Cuffs	Crimpea		<u> </u>	Contamination	\vdash	ntenance	- Circlear	Part Moved		I wrong stock rulled		
-		at .		<u> </u>	Countersink	-	abeled		Positioned \				
<u> </u>	Heat Treat Inspection Strip in Tube			-	Cut Too Short	Misr			Power Loss/		Other		
-	Ripples in	-			Drill Holes	Offse		<u> </u>]		<u> </u>		
 	Torque V		Extrusio	n 📙	Drawing		of Calibration						
<u> </u>					Finish	—	Out of Sequence						
	Turning Sequence				Folio		ido Dimonsions						

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